

Work Order ID 59606

Tuesday, June 08, 2010 3:07:55 PM



Page 1

Item ID: D4017-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Base Assembly (350)

Start Date: 6/9/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *MF*Date: *10-6-8*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4017

B

100



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: *M113328*

0.00

Large Fab

Memo

0.00

- 1- assemble ribs , weld as per dwg D4017 using DT9610B
- ***inspect before welding mesh***
- 2- tack weld mesh on basket as per dwg D4017 and trim mesh to fit
- 3- weld hinge (3) and Mounting brackets as per dwg D4017
- ***take lid to locate hinge and bracket***

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

10/06/11 *(1x)**Pho →*
Qpl 10-06-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4017-041 PAR #: _____ Fault Category: Eng design NCR: ☒ Yes No DQA: [Signature] Date: 10-06-22
 Resolution: rework Disposition: rework QA: N/C Closed: [Signature] Date: 10/06/23

NCR: <u>59606</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/06/14</u>	<u>100</u>	<u>only bracket does not fit due to wide label plate L.C. Design Flaw</u>	<u>10.06.14</u> <u>BS1043</u>	<u>cut out groove for mtg bracket to fit this basket only. Not structural prob deviation.</u>	<u>[Signature]</u> <u>10/06/14</u>	<u>[Signature]</u> <u>10/06/14</u>	<u>10.06.14</u> <u>BS1043</u>	<u>[Signature]</u> <u>10/06/14</u>
				<u>Only already under review correcting the issue.</u> <u>[Signature]</u> <u>10/06/22</u>				

NOTE: Date & initial all entries

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 6/9/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

150



HandFinish

Hand Finishing

Assemble as per dwg

0.00

Memo

0.00

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

EP 10/06/15 @

10/06/15
MF
10-6-15

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Page 1

[illegible]

Required Date: 6/14/2010

Required Qty: 1.00

[illegible]

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Page 2

Work Order ID: 59606



Parent Item: D4017-041



Parent Item Name: Short Basket Base Assembly (350)

Start Date: 6/9/2010

Required Date: 6/14/2010

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC
per dwg RevA DD 10.03.06 verified by:EC
DD 10.04.16 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status												
✓ D3916-5		Manufactured	No			100	Each	11.0000	1	1															
Light Rib																									
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>WA</td><td>11</td><td></td></tr><tr><td>57023</td><td>2</td><td></td></tr><tr><td>59333</td><td>9</td><td></td></tr></table>														Location	Loc Qty	Loc Code	WA	11		57023	2		59333	9	
Location	Loc Qty	Loc Code																							
WA	11																								
57023	2																								
59333	9																								
✓ D4034-041		Manufactured	No			100	Each	5.0000	1	1															
Aft Upper Rib Assembly																									
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>WA</td><td>5</td><td></td></tr><tr><td>58696</td><td>2</td><td></td></tr><tr><td>58729</td><td>3</td><td></td></tr></table>														Location	Loc Qty	Loc Code	WA	5		58696	2		58729	3	
Location	Loc Qty	Loc Code																							
WA	5																								
58696	2																								
58729	3																								
✓ D4034-043		Manufactured	No			100	Each	4.0000	1	1															
Fwd Upper Rib Assembly																									
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WA	4																								
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Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)


Comments: IPP RevA: new issue DD 09.11.30 verified by:EC
per dwg RevA DD 10.03.06 verified by:EC
DD 10.04.16 verified by:EC

Start Date: 6/9/2010

Required Date: 6/14/2010


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
D2581		Manufactured	No			100	Each	55.0000	2	2			
													
Mounting Bracket													


Location	Loc Qty	Loc Code
ST	22	
59121	22	
WA	33	
46086	2	
51745	2	
57185	1	
58687	7	
59265	21	

Handwritten: 10/06/10

D3913-15	Manufactured	No				100	Each	8.0000	1	1			
													
Wide Handle Plate													


Location	Loc Qty	Loc Code
WA	8	
58125	5	
58586	3	

Handwritten: 10/06/10

D4016-1	Manufactured	No				100	Each	9.0000	3	3			
													
Hinge Half, Base													

Location	Loc Qty	Loc Code
WA	9	
58745	9	

Handwritten: 10/06/10

D4020-3	Manufactured	No				100	Each	0.0000	1	1			
													
Mesh (350 Basket Short, Base)													

Handwritten: B59615 ① 10/06/11

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DD 10.04.16 verified by:EC

Start Date: 6/9/2010


Required Date: 6/14/2010

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
✓ D4020-11		Manufactured	No			100	Each	6.0000	2	2			
													
End Mesh, Basket													


Location	Loc Qty	Loc Code
WA	6	
56990	1	
58136	1	
58931	4	

D2931	Manufactured	No	150	Each	838.0000	2		
								
Bumper								

Location	Loc Qty	Loc Code
ST504	838	
46064	838	

✓ D4021-1	Manufactured	No	100	Each	19.0000	3	3	
								
Handle Plate								

Location	Loc Qty	Loc Code
ST109	5	
57086	5	
WA	14	
58746	5	
59336	9	

✓ D4021-5	Manufactured	No	150	Each	11.0000	2	2	
								
Blanking Plate								

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Page 4

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DD 10.04.16 verified by:EC

Start Date: 6/9/2010

Required Date: 6/14/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
AN3-10A		Purchased	No			150	Each	18.0000	6	6			
Bolt													
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
					ST351			18					
					114330			18					
*AN960JD8	NAS1149DN832J	Purchased	No			150	Each	0.0000	2	2			
Washer													
MS20600-AD4W3		Purchased	No			150	Each	1,769.000	2	2			
Cherry Rivets													
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
					ST321			1769					
					106375			3					
					107939			822					
					111636			944					
MS21042L3		Purchased	No			150	Each	3,364.000	6	6			
Nut													
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
					ST300			3364					
					113537			18					
					113644			5					
					114523			841					
					114718			500					
					114784			2000					

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Page 6

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Required Date: 6/14/2010

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC
per dwg RevA DD 10.03.06 verified by:EC
DD 10.04.16 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
NAS1149F0332P		Purchased	No			150	Each	755.0000	12	12			
WASHER													



EP 6/06/15

Location

Loc Qty

Loc Code

ST275

755

18057

755

12

Tuesday, June 08, 2010 3:07:55 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

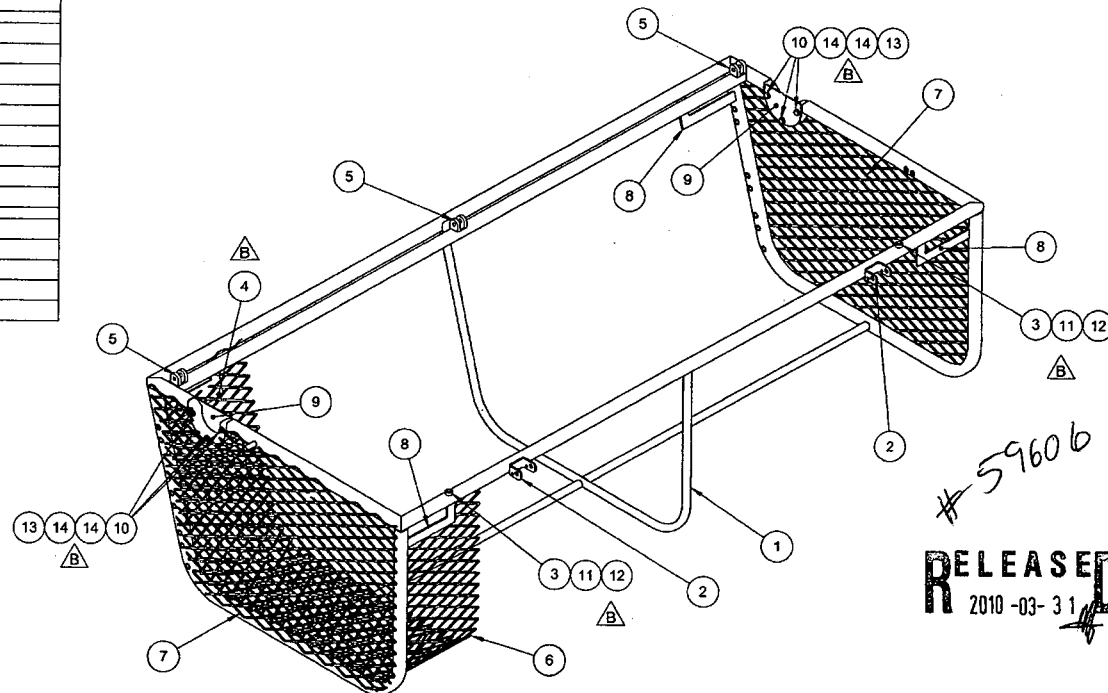
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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ITEM	QTY -041	P/N	DESCRIPTION
	X	D4017-041	SHORT BASKET BASE ASSY (350)
1	1	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
2	2	D2581	MOUNTING BRACKET
3	2	D2931	BUMPER
4	1	D3913-15	WIDE HANDLE PLATE
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-3	MESH (350 BASKET SHORT BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



RELEASED
2010-03-31

D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 28.8 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

B	QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15; AN3-10A BOLT WAS AN3C10A; NAS1149F0332P WASHER WAS NAS1149C0332P; SECTION F-F UPDATED (D6-2); ITEMS RENUMBERED; DETAIL D UPDATED (A4-3)	JPH	10.03.25
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4017	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET BASE ASSY (350)	NTS
DATE	10.03.25	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

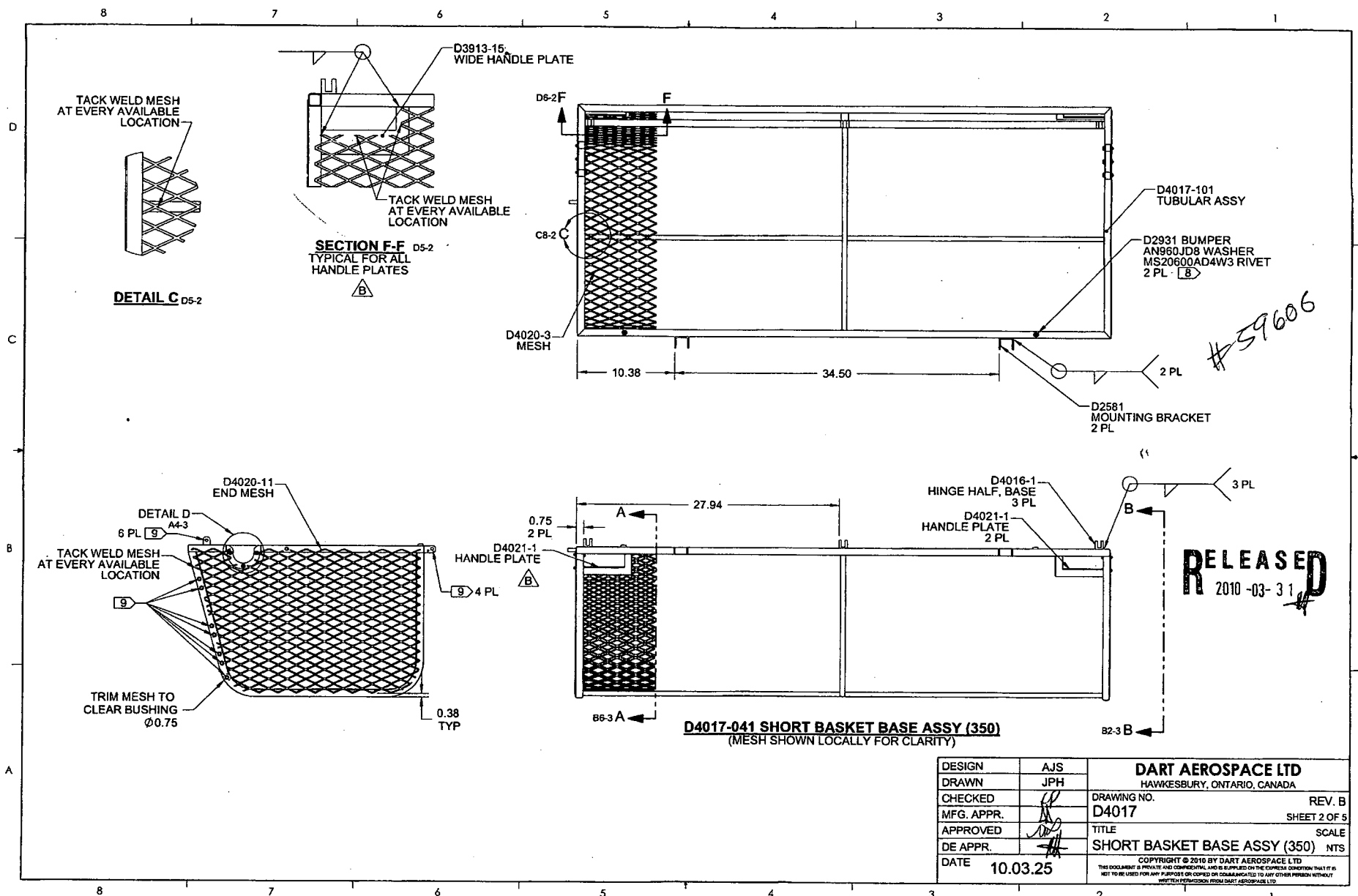
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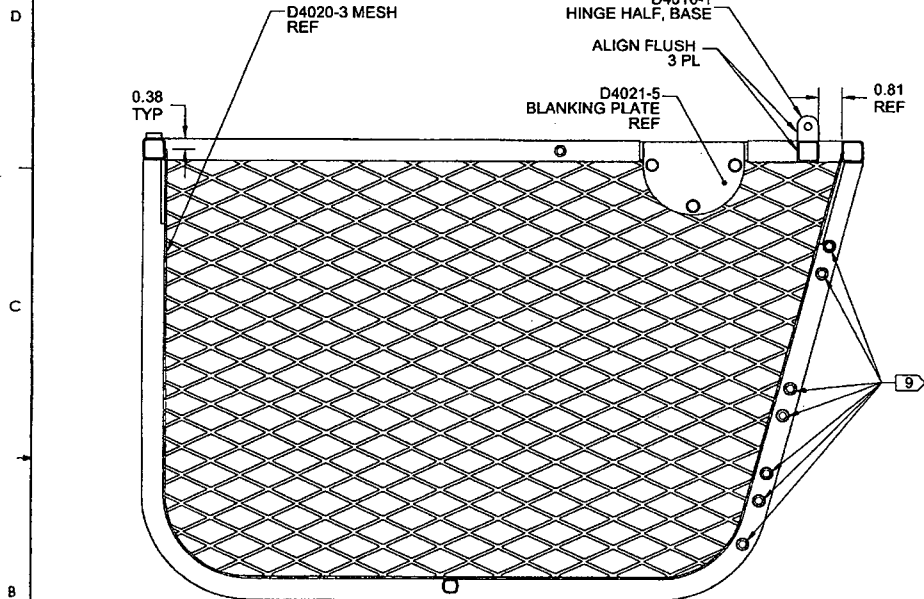
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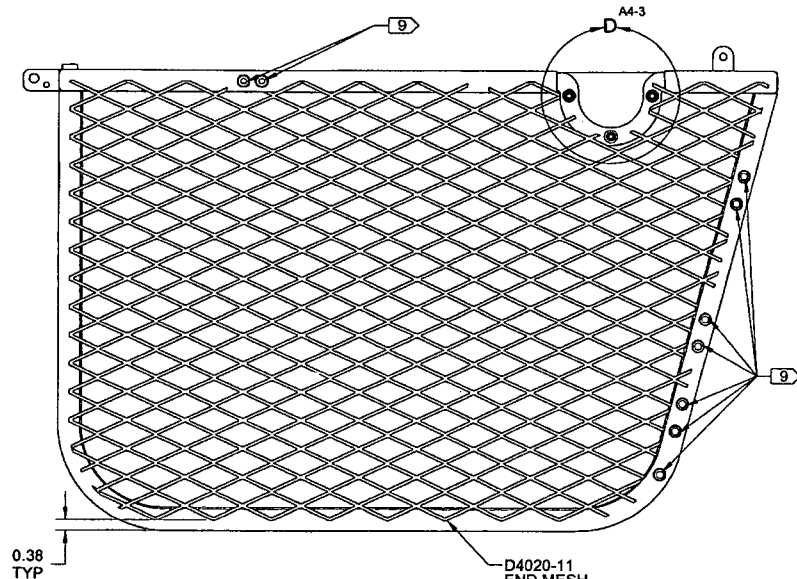
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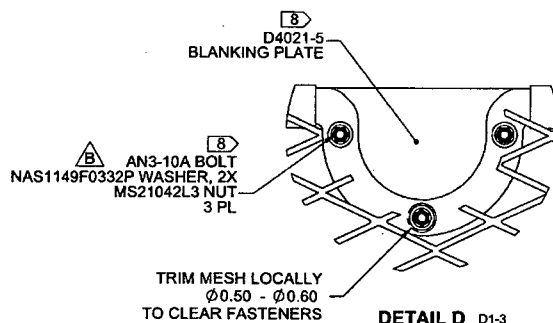
8 7 6 5 4 3 2 1



SECTION A-A A5-2






SECTION B-B A2-2



DETAIL D D1-3 B6-2

#59606

RELEASED
2010-03-31

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	B	DRAWING NO.	REV. B
MFG. APPR.		D4017	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET BASE ASSY (350)	NTS
DATE	10.03.25	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1

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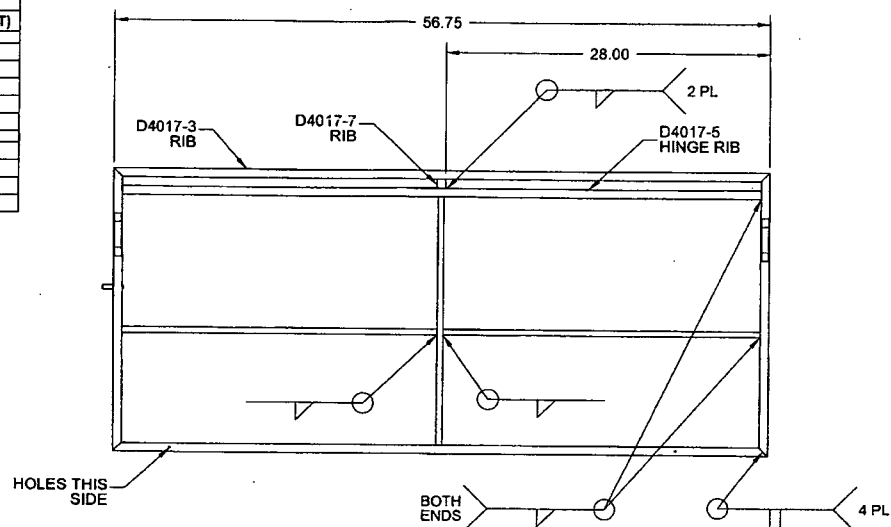
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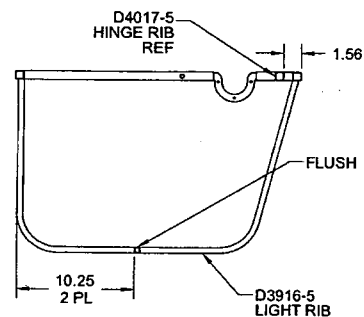
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NOTE: Date & initial all entries

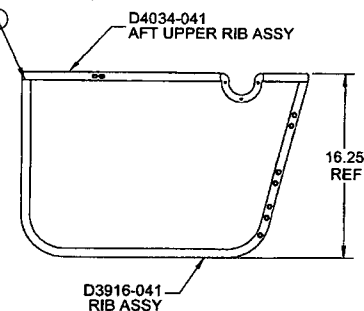
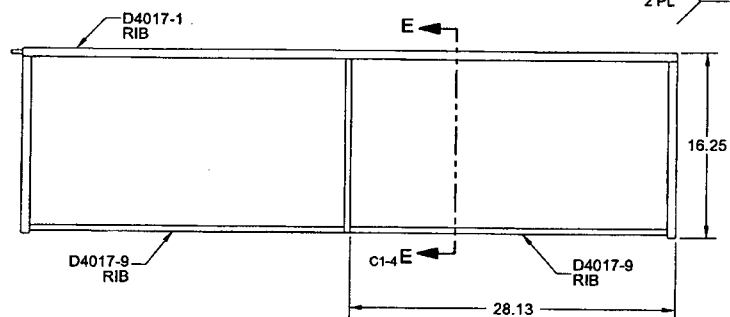
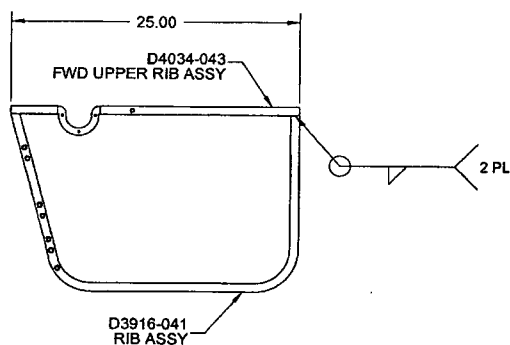
ITEM	QTY -101	P/N	DESCRIPTION
	X	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
1	1	D4017-1	RIB
2	1	D4017-3	RIB
3	1	D4017-5	HINGE RIB
4	1	D4017-7	RIB
5	2	D4017-9	RIB
6	2	D3916-041	RIB ASSY
7	1	D3916-5	LIGHT RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY



#59600
RELEASED
 2010-03-31







SECTION E-E A4-4



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 15.28 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4017-101
- 9) WELD PER DART QSI 004

8 D4017-101 TUBULAR ASSY (350 SHORT BASKET)

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4017	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET BASE ASSY (350)	NTS
DATE	10.03.25	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

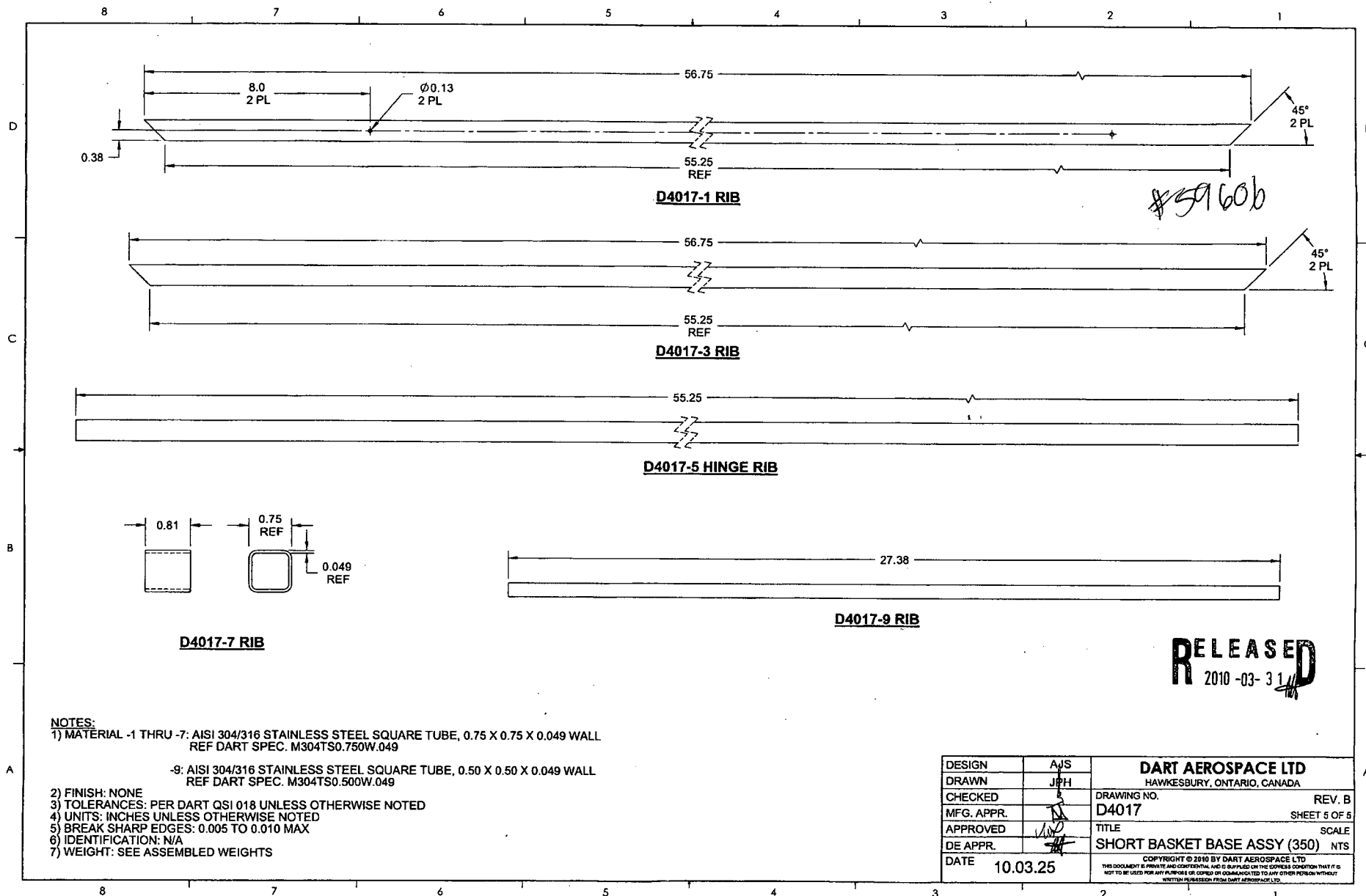
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Marc Bellavance

From: David Shepherd [dshepherd@dartaero.com]
Sent: June 14, 2010 2:36 PM
To: 'Marc Bellavance'
Cc: 'Mike Petsche'
Subject: RE: D350-607-44X - D4017-041 Short Basket Base Assy

Seems like a reasonable solution to me.

David

From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: Monday, June 14, 2010 11:54 AM
To: 'David Shepherd'
Cc: 'Mike Petsche'
Subject: RE: D350-607-44X - D4017-041 Short Basket Base Assy

David,

Please see attached pictures.

- D4017-041 Interference shows... Interference.
- D4017-041 Cutout shows... Cutout to eliminate interference

Marc Bellavance
Mechanical Designer/Technical Support

DART aerospace Ltd.

Tel: 613-632-5200 Ext. 240

Fax: 613-632-9311

E-mail: mbellavance@dartaero.com

Web: www.dartaero.com



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From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: June 14, 2010 10:10 AM
To: 'David Shepherd'
Cc: 'Mike Petsche'
Subject: D350-607-44X - D4017-041 Short Basket Base Assy
Importance: High

David,

Manufacturing is making a new short basket base assembly.

Interference was noticed just before sending to finishing between the D3911-043 Aft Eyebolt Receiver Assy and D3913-15 Wide Handle Plate upon trying to install the D3911-043 Aft Eyebolt Receiver Assy onto the base.

The solution we came up with is to cut a 0.25" wide X 0.50" long slot in D3913-15 to allow installation of D3911-043 onto the basket base. That takes care of this basket. On future short basket base, the D3913-15 should be installed outboard and the D4021-1 inboard.

Marc Bellavance

Mechanical Designer/Technical Support

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E-mail: mbellavance@dartaero.com

Web: www.dartaero.com



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